












# Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 205 SKIDTUBE "I" BEAM
Job Number	: 31213		
Estimate Number	: 10346		
P.O. Number	: N/A	Part Number	: D2596
This Issue	: 3/14/2007	S.O. No. :	N/A
Prsht Rev.	: NC	Drawing Number	: D2596 REV C
First Issue	: 3/14/2007	Project Number	: N/A
Previous Run	: 31110	Drawing Revision	: C
		Material	: N/A
Written By	:	Due Date	: 3/23/2007
Checked & Approved By	:	Qty:	6 Um: Each
Comment	: Est: D 99.02.02 Changed QA to QC, Added Step 6 and Cost D M		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	D25003100	Ext'n - I" Beam Web 4"	
			
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) Extrusion "I" Beam Web 4" Pick; Qty Part Number Description Batch 1 D2500-3-100 Extrusion B 25 751 7-3-21			
2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1	
			
<b>Comment:</b> LANDING GEAR RESOURCE 1 1- Cut D2500-3-100 to length: 99.5" 2- Use Jig DT8093 to drill pilot holes #30 3- Open to 0.630" diameter as per Dwg D2596 4- Deburr			
3.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
			
<b>Comment:</b> HAND FINISHING RESOURCE #1 Acid Etch and Alodine per QSI 005 4.1			
4.0	QC5	INSPECT WORK TO CURRENT STEP	
			
<b>Comment:</b> INSPECT WORK TO CURRENT STEP			
5.0	PACKAGING 1	PACKAGING RESOURCE #1	
			
<b>Comment:</b> PACKAGING RESOURCE #1 Identify and Stock Location: L6			



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/01/22  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Date: Wednesday, 3/14/2007 3:28:33 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 SKIDTUBE "I" BEAM

Job Number: 31213

Part Number: D2596

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

1707/03/22

Job Completion



u 07-03-22



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

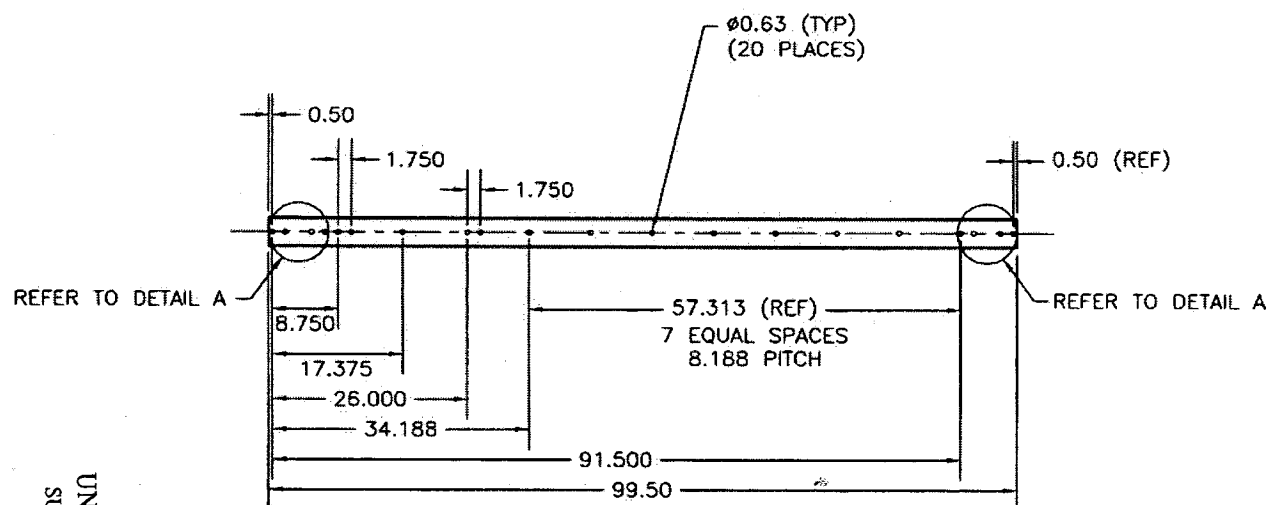
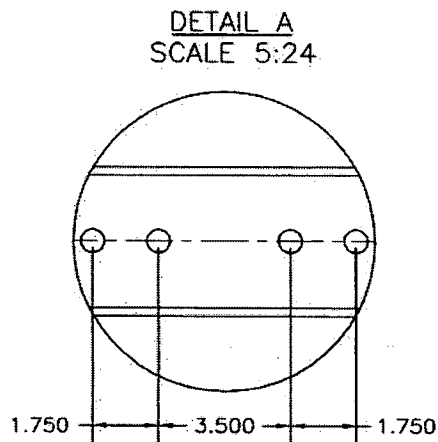


**DART**



**RELEASED**  
98.09.17 DS

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. C
CHECKED	APPROVED	DRAWING NO. D2596	SHEET 1 OF 1
DATE	TITLE	205 WEB	SCALE
98.09.14			1:24
A	96.09.16	NEW ISSUE	
B	97.07.23	Ø0.63 HOLE WAS Ø0.56	
C	98.09.14	INCORPORATED DEO 9097	



MANUFACTURED FROM D2500-3 EXTRUSION  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 31213